

Date: Monday, 6/26/2006 3:46:30 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	BASKET LID ASSY (A119)
<b>Job Number</b> :	27693A		
<b>Estimate Number</b> :	12445		
<b>P.O. Number</b> :	NIA	<b>Part Number</b> :	D3515041
<b>This Issue</b> :	6/26/2006	<b>S.O. No.</b> :	NIA
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3515 PRELIMINARY
<b>First Issue</b> :	NIA	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	NIA	<b>Drawing Revision</b> :	PRELIMINARY
	<b>Type</b> :	<b>Material</b> :	NIA
	LARGE FAB ASSY	<b>Due Date</b> :	7/3/2006
<b>Written By</b> :	<i>See Comment Below</i>		<b>Qty:</b> <i>2x</i> <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	<i>06.06.26</i>		
<b>Comment</b> :	EST rev. A 06.06.05 Preliminary EC		<i>1 scrap</i>

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D22321	Hinge
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 Basket Hinge  
 Batch: *25238*

2.0	D31663	Basket Hoop
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Basket Hoop  
 Batch: *B25896*

3.0	D23271	Spacer Bushing
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 Spacer Bushing  
 Batch: *26742*

4.0	D2506	Placard
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Placard  
 Batch: *26677-2*

5.0	D2581	Mounting Bracket
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 Mounting Bracket  
 Batch: *B26204*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/26/2006 3:46:31 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASS'Y (A119)

Job Number: 27693A

Part Number: D3515041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

M304TS0750W065

304 SQ Tube.75x.75x.065W



Comment: Qty.: 43.5750 f(s)/Unit Total : 43.5750 f(s)

AISI 304 SQ Tube.75x.75x.065W

Batch: 1100783

AS

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut rib D3515-1 as per dwg D3516

2-Cut rib D3515-3 as per dwg D3516

3-Cut rib D3515-5 as per dwg D3516

4-Cut rib D3515-7 as per dwg D3516

5-Cut Rib (4) D2236 from D3166-3 per dwg D2236

AS

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3515

AS

9.0

QC5 19

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD

*[Signature]*

10.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 21.0000 sf(s)/Unit Total : 21.0000 sf(s)

Expanded Metal Flat Stainless steel

Batch: 1100999

AS

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut expanded metal for base as per dwg D3516

2-Cut expanded metal for base ends as per dwg D3516

3-Weld expanded metal to base as per dwg D3516

AS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: LD Date: 06/07/24

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/26/2006 3:46:31 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASS'Y (A119)

Job Number: 27693A

Part Number: D3515041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

PD

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

mm 6.06.28 (1)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: —

PD

16.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.07.20

Job Completion



U 06.07.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

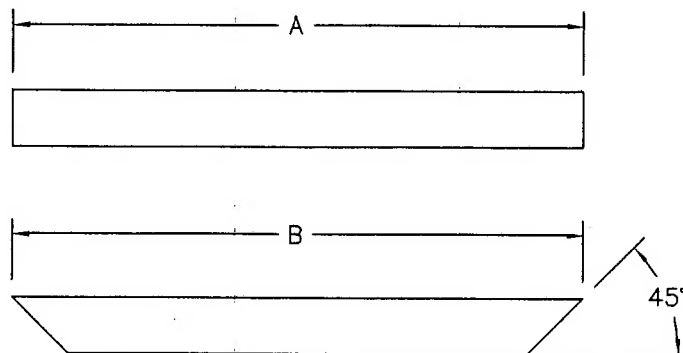
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

PRELIMINARY ISSUE

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3515	REV.-A SHEET 1 OF 4
DATE 06.05.05		TITLE BASKET LID ASSEMBLY (A119) SCALE NTS	
A	06.05.05	NEW ISSUE	

**PARTS LIST FOR D3515-041 BASKET LID ASSEMBLY**

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3515-1	2	—	25.50	RIB
D3515-3	2	—	101.30	RIB
D3515-5	6	33.84	—	RIB
D3515-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



**D3515-1/-3/-5/-7**

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING  
(REF. DART SPECS. M304TS0.750W.065)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

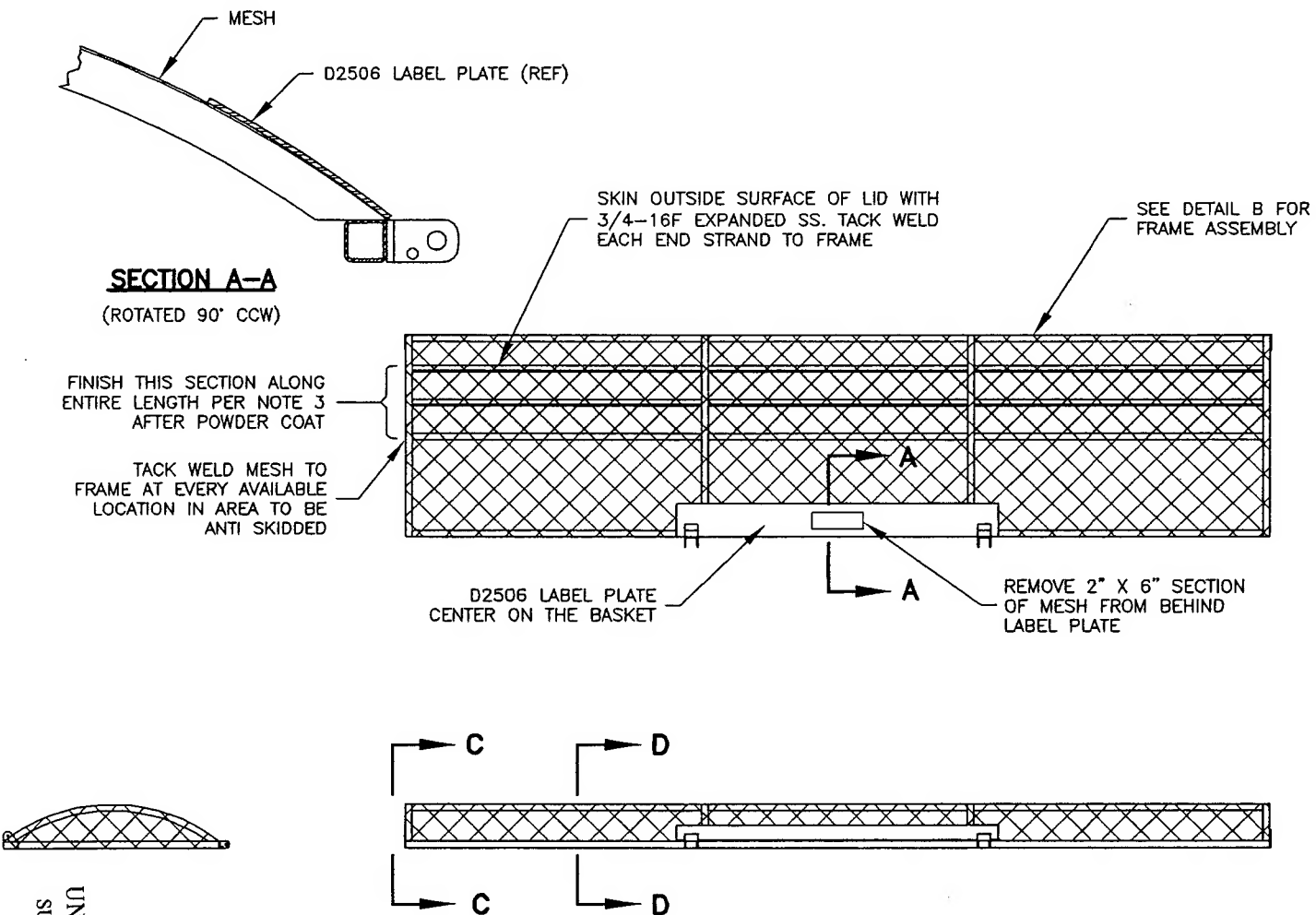
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **27693A**

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CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	
DATE	DRAWING NO.	SHEET 2 OF 4	
06.05.05	D3515	BASKET LID ASSEMBLY (A119)	SCALE 1:20



## D3515-041 BASKET LID ASSEMBLY

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF. DART SPEC. M304EX0.75-16F)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) SPRAY PAINT BLACK INSIDE SURFACE  
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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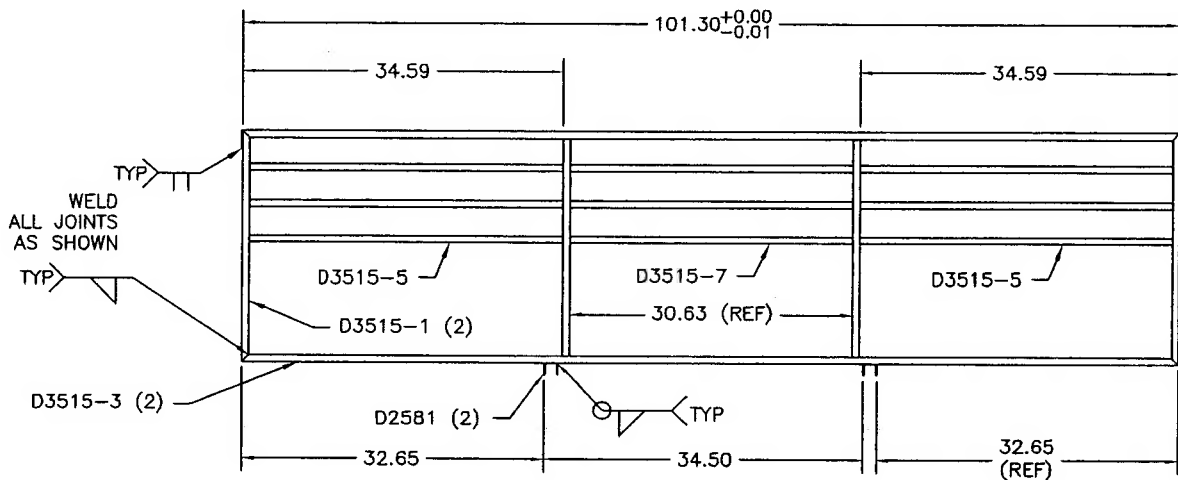
WITHOUT NOTICE

WORK ORDER  
NO. 27693A



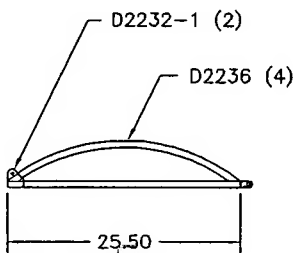
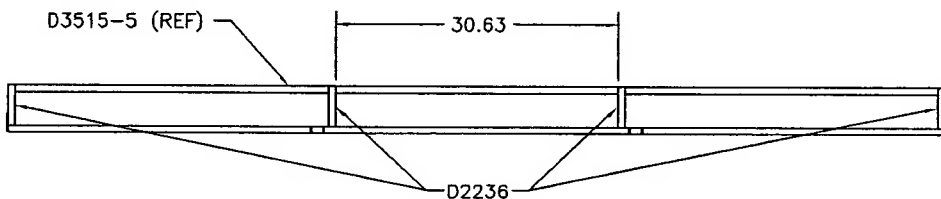
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DATE	06.05.05	DRAWING NO.	D3515	REV. A
		TITLE	BASKET LID ASSEMBLY (A119)	SHEET 3 OF 4
		SCALE	1:20	



## DETAIL B

FRAMEWORK SHOWN FOR CLARITY  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

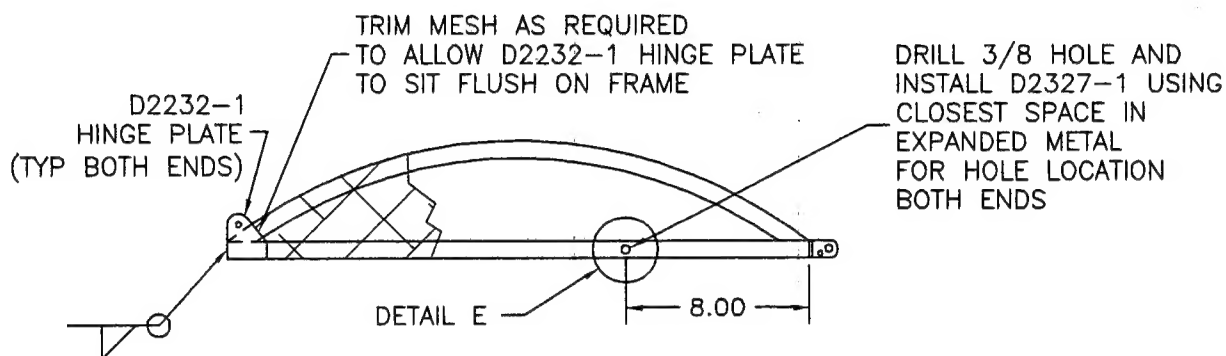


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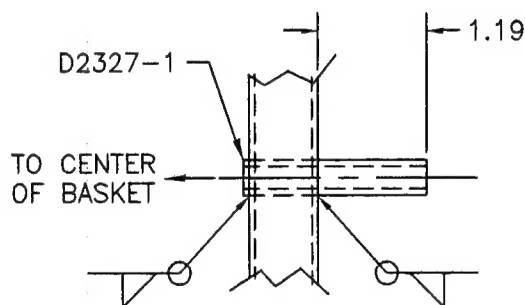
WORK ORDER  
NO. 276934

# PRELIMINARY ISSUE

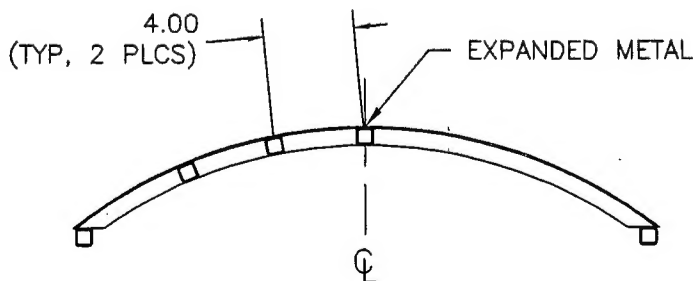
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CHECKED	APPROVED	DRAWING NO. D3515	REV. A SHEET 4 OF 4
DATE 06.05.05		TITLE BASKET LID ASSEMBLY (A119)	SCALE 1:8



**SECTION C-C SIMILAR BOTH END RIBS**



**DETAIL E**



**SECTION D-D SAME BOTH CENTER RIBS**

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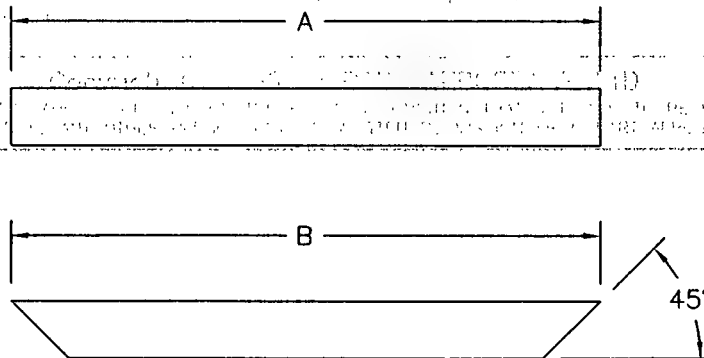
06.05.25

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CHECKED	APPROVED	DRAWING NO. D3515	REV. A SHEET 1 OF 4
DATE 06.05.05		TITLE BASKET LID ASSEMBLY (A119)	
A	06.05.05	NEW ISSUE	

**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
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06.05.25

## PARTS LIST FOR D3515 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3515-1	2	—	25.50	RIB
D3515-3	2	—	101.30	RIB
D3515-5	6	33.84	—	RIB
D3515-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



**D3515-1/-3/-5/-7**

CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

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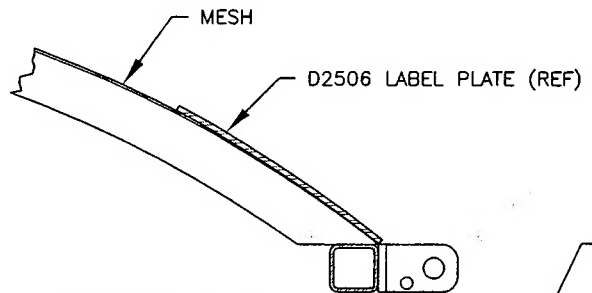
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**PRELIMINARY ISSUE**

06-03-25

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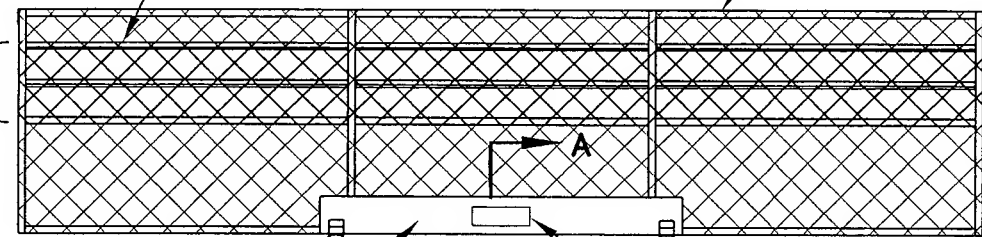


**SECTION A-A**  
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG  
ENTIRE LENGTH PER NOTE 3  
AFTER POWDER COAT.

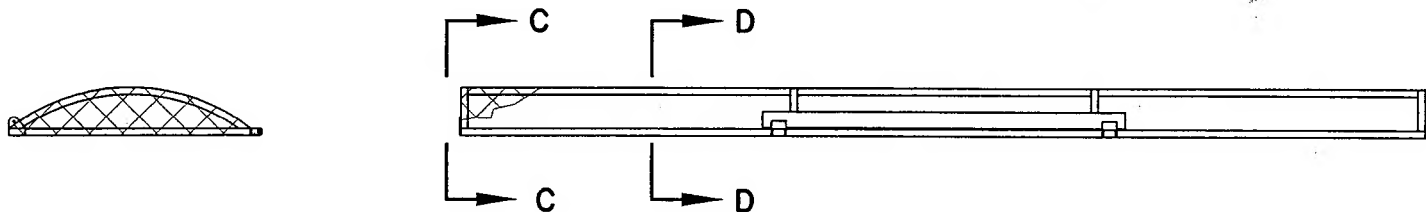
SKIN OUTSIDE SURFACE OF LID WITH  
3/4-16F EXPANDED SS. TACK WELD  
EACH END STRAND TO FRAME

SEE DETAIL B FOR  
FRAME ASSEMBLY



D2506 LABEL PLATE  
CENTER ON THE BASKET

REMOVE 2" X 6" SECTION  
OF MESH FROM BEHIND  
LABEL PLATE



**D2512 BASKET LID ASSEMBLY**

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE  
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

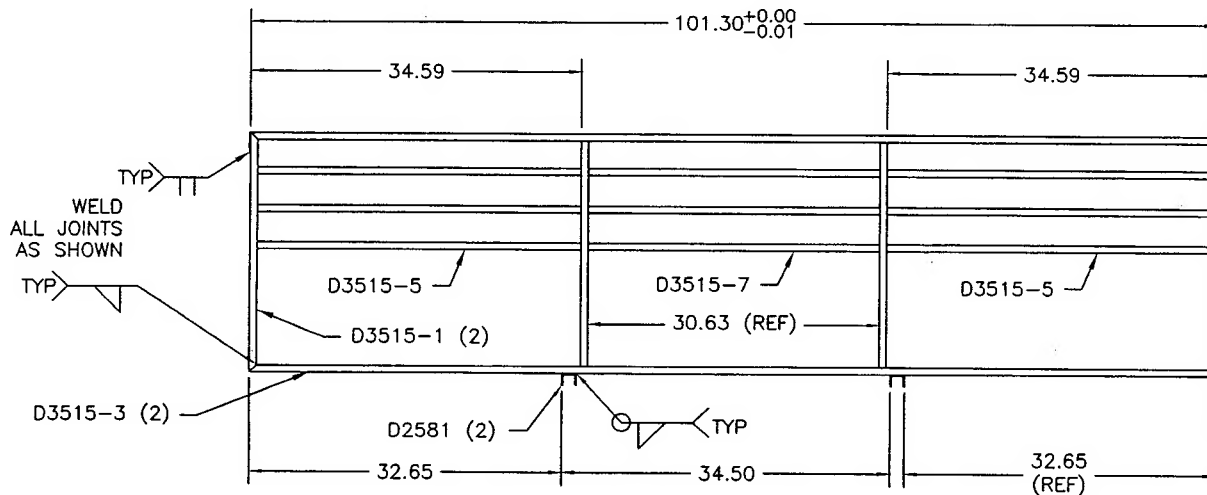
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DATE	DRAWING NO.	REV. A
06.05.05	D3515	SHEET 2 OF 4
	TITLE	SCALE
	BASKET LID ASSEMBLY (A119)	1:20

**PRELIMINARY ISSUE**

06.03.25

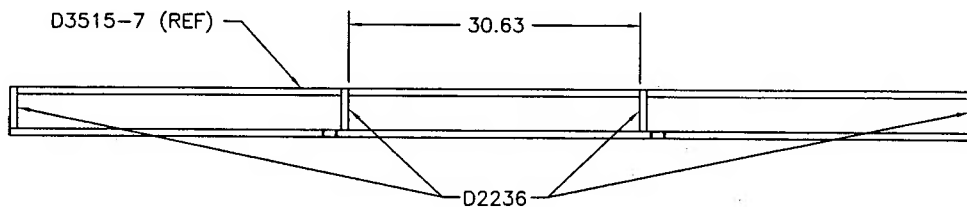
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DATE	TITLE	REV. A
06.05.05	BASKET LID ASSEMBLY (A119)	SHEET 3-OF-4
		SCALE
		1:20

**PTO**



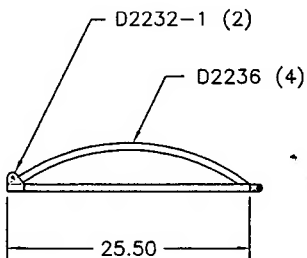
**DETAIL B**

FRAMEWORK SHOWN FOR CLARITY  
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**PROTOTYPE**  
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A2581 QTY ~~1~~ 4 B26204

A2232-1 QTY ~~1~~ 4 B 25238

A2327-1 QTY ~~1~~ 4 B 26742

D3166-1 QTY ~~1~~ 2 A25896

D2506 ~~QTY 1~~ QTY 1 B26031-2

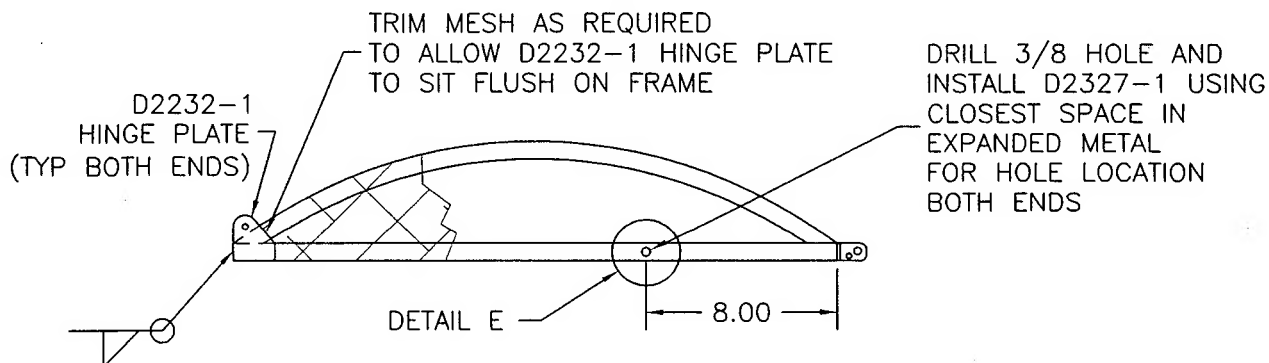
$\frac{3}{4}$ " x  $\frac{3}{4}$ " x  $\frac{1}{2}$ " wall 304/316 SS Tubing M100783

\* Had to scrap Lid and make one more  
Parts and Tubing

**PRELIMINARY ISSUE**

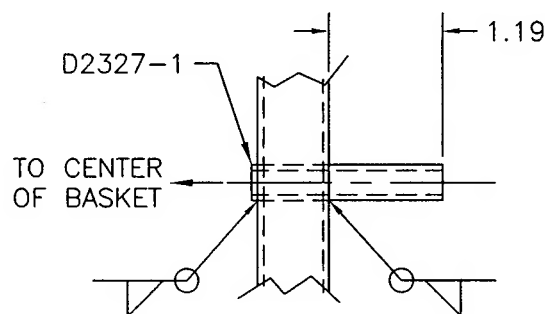
06-05-25

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3516	REV. A SHEET 4 OF 4
DATE 06.05.05	TITLE BASKET LID ASSEMBLY (A119)		SCALE 1:8

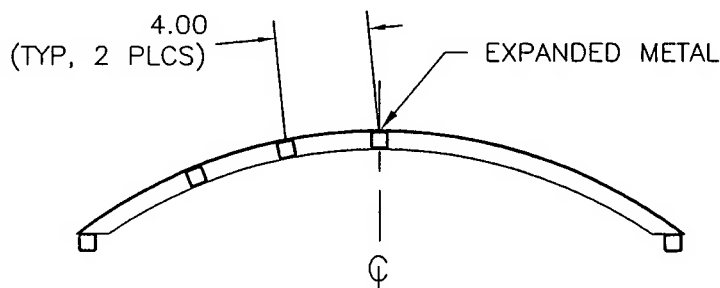


**SECTION C-C SIMILIAR BOTH END RIBS**

**PROTOTYPE**  
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06-05-25



**DETAIL E**



**SECTION D-D SAME BOTH CENTER RIBS**

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